Qty:

Friday, 9/21/2007 1:19:11 PM

User

Kim Johnston

**Process Sheet** 

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 34828

**Estimate Number** 

: 12716

P.O. Number

This Issue

Prsht Rev.

First Issue

: HA

: 9/21/2007

: NC

: 9/21/2007 : 33659

Type

S.O. No. : NA

: SMALL /MED FAB

Part Number **Drawing Number** 

**Drawing Name** 

: D353635 D3536 REV A

: GASKET

: N/A Project Number : A

**Drawing Revision** :NA Material

: 9/28/2007 Due Date

Each

Written By

Previous Run

Checked & Approved By Comment

: Est RevA

New Issue 07-02-14 JLM

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

NEOPRENE SHEET 0.063

1.0

MNEO60S063

Comment: Qty.: 0.6507 sf(s)/Unit

21.4731 Total: 19.5206 sf(s)

NEOPRENE SHEET 0.063

Batch: M(65115

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev: \_\_\_ Prog Rev:\_\_

B 07-10-3



2-Deburr if necessary

3.0

QC2



B 07-10-3



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

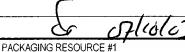
QC8

SECOND CHECK



Comment: SECOND CHECK

5.0 PACKAGING 1





Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



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<b>Dart Aerospace Lt</b>	d	d	∟to	L	е	C	a	0	S	O	r	e	Α	rt	)a	C
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W/O:			WORK ORDER CHANGES						
DATE	STEP	i L	PROCEDURE CH	PROCEDURE CHANGE		Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #	: Fault Cat	egory:					
		10 10	ļ		QA: N/	C Closed:	Date: _	<del></del>	
NCR:		· · · · · · · · · · · · · · · · · · ·	WORK OR	DER NON-CONFORMA	NCE (NCR	)			
		Description of N		Corrective Action Section	ction B Verification App				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	

NOTE: Date & initial all entries

Date:

Friday, 9/21/2007 1:19:11 PM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 34828

Part Number: D353635

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd
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W/O:			V	VORK ORDER CHANG	ES			
DATE	STEP				Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
			1					2-
Part No	:	PAR #:	Fault Ca	tegory:		No DQA:		
NCR:		1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	WORK OR	DER NON-CONFORMA			Date	
DATE	STEP	Description of NO Section A	C Corrective Action Initial Action Descri		on B Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspecto
			J	Criter Eng	Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34828	
Description: Gasket	Part Number:	D3536-35	
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.25	+/-0.030	33.25	¥			
19.75	+/-0.030	19.75	×e			
17.75	+/-0.030	וואכ	×			
14.25	+/-0.030	14.25	×			
9.50	+/-0.030	9.50	×			
4.75	+/-0.030	4.75	<b>∞</b>			
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6.00	+/-0.030	6.00	×			
6.75	+/-0.030	6.75	æ			
0.30	+/-0.030	30				
0.30	+/-0.030	,30	×			
1.89	+/-0.030	1.88	¥			
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0.063	+/-0.010	'063	×			
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				(4)	
Measured by:	tB	Audited by:	8	Prototype Approval:	N/A
Date:	07-10-3	Date:	Hale?	Date:	N/A

Rev	Date	Change	Revised by	Approyed
Α	07.03.14	New Issue	KJ/JLM	
			171	7,0,7

CHECKED

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D3536

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-유 SCALE 1:10

DRAWING NO.

DART

AEROSPACE PORT HADLOCK,

NC.

B

DATE

06.10.25

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NEW V

**ISSUE** 

GASKET

202.12 

	0.90
5.65	1.89
3.90	1

D3536-11 GASKET

26.65

23.15 -- 21.15 – 17.65

13.40 ---

INCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE SHOP COPY WORK ORDER ENGINEERING RETURN TO

DETAIL A

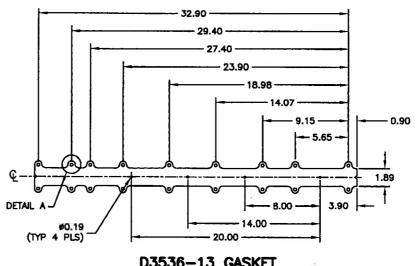
#0.19 (TYP 3 PLS)

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT &
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-13 GASKET

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OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	I IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY I	
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D3536-15 GASKET

24.00

JNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE ENGINEERING SHOP COPY WORK ORDER RETURN TO 2) FINISH: NONE

3) PART IS SYMMETRICAL ABOUT ©

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

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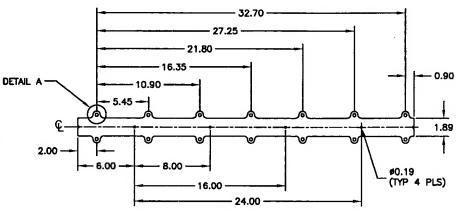
RT AEROSPACE USA, INC.

PURPOSE

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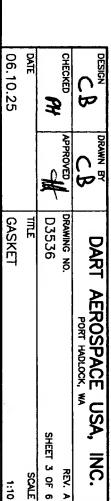
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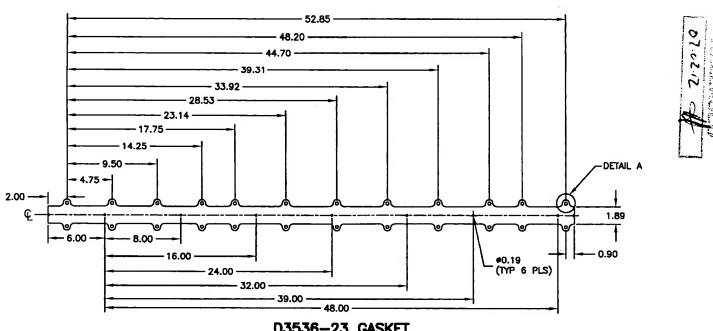
7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-21 GASKET







D3536-23 GASKET

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1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

2) FINISH: NONE 3) PART IS SYMM

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**PURPOSE** 

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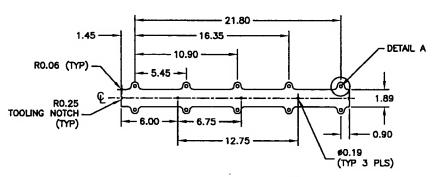
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TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

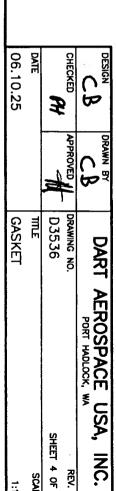
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DIDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION

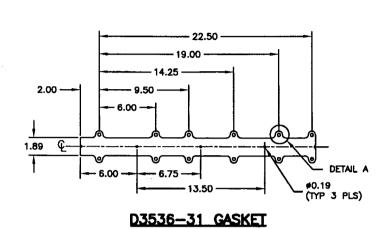


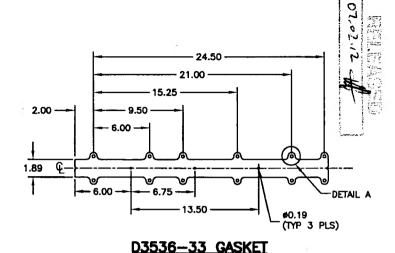
D3536-25 GASKET





SCALE 1:10





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D3536-35 GASKET

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- DETAIL A

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- 2) FINISH: NONE 3) PART IS SYMM
- PART IS SYMMETRICAL ABOUT & TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
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PERMANENT INK MARKER
SEE PAGE 6 FOR DETAILS AND SECTION
SEE PAGE 8 FOR DETAILS AND SECTION
SHOP COPY
RETURN TO
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WORK ORDER

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30.75 27.25 22.50 -17.75 2.00 9.50 4.75 1.89 Ę - 6.00 8.00 16.00 DETAIL A 21.00 #0.19 (TYP 4 PLS) D3536-37 GASKET

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PURPOSE

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1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEOBO-S.063)

2) FINISH: NONE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER
7) SEE PAGE 8 FOR DETAILS AND SECTION

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2.00 — Q	23.25 ————————————————————————————————————	1
	9.00 - 28.00 -	DETAIL A

D3536-39 GASKET

 $\mathcal{Z}$ (D<sup>型</sup> D3536 GASKET DRAWING NO. DART AEROSPACE PORT HADLOCK, ≸ USA, SHEET NC. G REV. A SCALE 읶

27.98 25.08 18.50 15.00 2.00 ~ 1.88 4.00 #0.19 (TYP 2 PLS) 3.90 **DETAIL** 

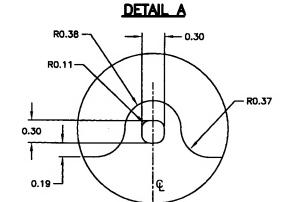
D3536-41 GASKET

07.02.12

- MOTES

  1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
  DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMM
- PART IS SYMMETRICAL ABOUT &
  TOLERANCES ARE PER DART QSI 018 UNLESS
  OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
  6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

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 CB	CB	DART A	DART AEROSPACE USA, INC.	<sup>™</sup> USA,	NC.
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DATE		TIME			SCALE
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